

REVISED (28.06.2006)



**Minutes of the QUALANOD Technical Committee meeting  
held on 18 November 2005 (8h30 – 11h00)  
in Porto Carras Grand Resort (Greece)**

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TC members:

**ESTAL**

J. Bettencourt (Chairman)  
R. Boi  
P. Lloret  
S. Meirsschaut

**EAA**

Å. Andersson  
E. Arnoux  
R. Furneaux  
W. Mader

Guest:

A. Cosentino  
M. Koot (EC)

Secretariat:

J. Schoppig  
P. Bellot (Minutes)

Apologies:

R. Wunderlin

C. Baroni



## AGENDA

1. Minutes of the meeting held on 22 June 2005
2. Statistical report
3. Coil anodizing
4. Chloride content
5. QUALISURFAL – meeting held in Rome on 5 September 2005
6. Abrasion test / purchase of abrasive paper
7. ASESAN's remarks on light fastness
8. Composition of the Technical Committee in 2006/2007
9. CEN TC 132 / WG 15
10. Any other business
11. Next meeting



The Chairman of the Technical Committee, Mr. Bettencourt, welcomed the delegates and the guest, Mrs. Agnieszka Cosentino, president of the Polish association, QUALIPOL.

### 1. Minutes of the meeting held on 22 June 2005

*The minutes of the previous meeting were unanimously approved.*

Mr. Mader pointed out that the summary of the last 3 weight loss test values had not been included on the last inspection form circulated, although it had been decided at the previous meeting to retain this summary in order to maintain better records (see item 2 of the minutes of the previous meeting).

*The secretariat would check this matter and amend the inspection form accordingly.*

### 2. Statistical report

Mr. Schoppig commented on the list of unsatisfactory inspections based on the reports received between 1 June and 31 October 2005. Five inspections out of 142 (3.5%) had been negative. The reasons for a negative result were a high weight loss (2), insufficient thickness (2) and insufficient in-house control (1). In the previous period (01.11.05 – 31.05.05), four inspections out of 162 (2.5%) had been negative, but only one had been unsatisfactory due to the weight loss test.

The list of all the weight loss values reported by the testing laboratories between 1 June and 31 October 2005 included one extremely poor result (weight loss of 142 mg/dm<sup>2</sup>). In this case, the national association concerned had taken all the necessary

measures according to §5.2.2.1 of the Specifications, and the repetition visit had been satisfactory.

The Technical Committee members agreed that the results were good and that the tendency remained positive.

Following the TC's instructions, the secretariat had also prepared a summary of the abrasion test results recorded in the 142 inspection reports which had been received between 1 June and 31 October 2005. Out of the 75 abrasion tests carried out by the inspectors, only one had failed (dense chalky deposit).

### 3. Coil anodizing

#### 3.1 Integration in the Specifications and inspection form

Mr. Bettencourt explained that the inspection form including coil anodizing had been presented at the QUALISURFAL meeting. It had then been revised in accordance with the applicant company's and Belgian inspector's remarks.

Those present discussed the new proposal and finally agreed to add the following text at the end of the addendum which had already been reviewed at the previous TC meeting:

#### **Inspections**

According to chapter 5, including at least:

- 1 weight loss test
- 150 thickness measuring points on
  - 3 running coils
  - And 9 coils on stock (or at least one coil of the stock and reference samples)

***The amended addendum would be included in the Specifications and an update sheet valid as from 1 January 2006 would be published as soon as possible.***

#### 3.2 Results of the process tests

Mr. Bettencourt commented on the tests which the Belgian laboratory had carried out on Coil's samples, in accordance with the new Appendix VI (Update Sheet No. 1). He reminded the delegates that the object of this study was to compare samples prepared by Coil to samples produced using traditional anodizing methods in order to be able to approve the process itself.

With the exception of the abrasion test, all the tests showed that the quality of the samples produced by the applicant company was as good as the quality of those made using the traditional anodizing process. Coil itself explained the problem of the abrasion test by the fact that they were working with a higher electrolyte temperature and higher current density. They doubted, however, that this really had any influence on the final quality of the product.

Although the Technical Committee members understood Coil's arguments, they thought that the applicant company should be able to control its process and they recommended that this matter be investigated more thoroughly.

***It was finally decided to ask the Belgian laboratory to carry out the referee test according to § 2.4.2 of the Specifications. If the result was satisfactory, the process would then be approved immediately and the inspector could make the first visit for granting a licence.***

***The applicant company and testing laboratory would be informed about the TC's resolutions. They would also be reminded that a QUALANOD licence was only granted for one production site.***

#### **4. Chloride content**

As a final contribution to the Technical Committee's work, Mr. van den Heuvel had proposed at the last meeting to prepare a paper about the influence of chloride. His comments on chloride impurity in anodizing electrolytes, which had been sent to all members, ended with the conclusion that the anodizing plants should keep the chloride content in sulphuric acid electrolytes below 250 mg NaCl.

At the previous meeting, the Technical Committee had stated that there was no need to check the chloride content as long as the water supply remained unchanged. It had therefore been decided that the "Specifications" working group would submit a proposal in order to incorporate the Technical Committee's statement into the Specifications. However this had not been done because the working group had not met since the June meeting and because Mr. van den Heuvel's paper had only been received a few weeks before this meeting.

Those present discussed the whole matter again and carefully reviewed the wording of § 3.2.8 of the Specifications.

***The Technical Committee finally came to the conclusion that it was neither necessary to change to an upper value nor to introduce any regulations concerning testing.***

#### **5. QUALISURFAL – meeting held in Rome on 5 September 2005**

The most important items discussed at the latest meeting of the Anodizing Section had been the preparation of the round robin test carried by LNEC, the problem of measurement uncertainty and some questions linked to the abrasion test.

As the inspectors had furthermore maintained that the instructions given for medium temperature sealing products were not always clear enough, the secretariat had asked the suppliers of the products tested and approved by QUALANOD to submit a current data sheet.

***The technical data sheets would be checked by Mr. Boi and be distributed to the national associations and testing laboratories.***

## 6. Abrasion test

### 6.1 Negative results of the abrasion resistance test (ÖVA's request)

The Austrian association ÖVA argued that the result of the abrasion test could not be positive when a 2-stage method using an acid tin bath was used to apply dark colours. This method was commonly used in Austria and produced a less hard surface. ÖVA requested QUALANOD to mention this impossibility clearly in the Specifications.

Mr. Boi agreed that electrolytic colouring could give rise to problems with the abrasion test. In order to obtain more information, it was also suggested that the statistics prepared by the secretariat be adapted by making a distinction between natural and electrolytically coloured products.

***This proposal was welcomed by the other attendees.***

The TC members acknowledged that the Austrian association's arguments were quite strong. However, the majority of them was convinced that, even with dark electrolytic colouring, it was possible to get a surface hard enough to pass the abrasion resistance test provided that each step of the process was monitored properly.

***The Austrian request was therefore rejected and ÖVA would be requested to ask the companies concerned to monitor their anodizing process better.***

Mr. Arnoux pointed out that the abrasion test was currently mandatory for in-house control and the inspections but did not have any consequences if the result was unsatisfactory. This gave the impression that QUALANOD was not really convinced of the use of the abrasion test. He thought that, at this stage, the abrasion resistance test should either disappear from the Specifications or become more significant.

Mr. Boi still considered the abrasion resistance test to be a very useful method for checking process conditions. This opinion was shared by the majority of the TC members.

***It was finally proposed that the referee test be applied automatically whenever the result of the abrasion resistance test was negative. If the result of the referee test was negative, the visit would be considered unsatisfactory.***

### 6.2 Purchase of abrasive paper

At the QUALISURFAL meeting, it had been suggested that QUALANOD should look into the possibility of centralised purchasing of abrasive paper through the secretariat. In the meantime, Mr. Schoppig had contacted the English company which produced the paper mentioned in the British standard.

The TC members agreed that only one paper should be used within QUALANOD, especially as it had been decided at this meeting to consider negative results of the abrasion resistance test to be grounds for repeating an inspection. They therefore welcomed the proposal for centralised purchasing of paper by the secretariat in order to get a better price.

***The national associations would be requested to inform the secretariat about the quantities of paper needed by their members. The secretariat would then place a global order with the supplier who would then send the abrasive paper directly to the national associations.***

## 7. ASESAN's remarks on light fastness

The Spanish association, ASESAN, had asked QUALANOD to confirm whether it was necessary to test electrolytic dyes and, if so, which tests had to be carried out.

Mr. Mader pointed out that the expression "electrolytic dyes" was incorrect. The correct term was "electrolytic salts".

Mr. Boi said that the statement in § 2.5 was a general specification which needed to be monitored. In the case of electrolytically coloured anodised aluminium, compliance with ISO 2135 was demonstrated.

Those present carefully reviewed the Specifications and amended § 2.5 and § 3.3.9 as follows:

### 2.5 Light fastness

#### ISO 2135

For external applications, the value must reach or exceed the figure of 8 on the international "Blue Scale".

Note that it has been demonstrated that electrolytically coloured anodised aluminium complies with this specification.

### 3.2.9 Colouring

When colouring parts, anodizers should use dyes that satisfy the light fastness test (see section 2.5).

The dye supplier's instructions on the temperature and pH value of the dye bath and time of immersion must be followed depending on the dye employed.

For external applications, the quality label may not be used for black electrolytic colouring using copper salts.

***The secretariat would incorporate the amended paragraphs into an update sheet which would be sent to all national associations.***

## 8. Composition of the Technical Committee in 2006/2008

Mr. Schoppig reminded the attendees that, under the Articles of Association, it was up to ESTAL and EAA to propose candidates for the committees. In a letter dated 7.10.05, he had therefore requested ESTAL and EAA to propose delegates for the period 2006-2007 by the end of March 2006.

***In June 2006, the QUALANOD meetings would start with the General Meeting which would then elect the Executive and Technical Committees.***

Mr. Arnoux informed the attendees that the June meeting would be his last QUALANOD meeting as he was retiring in summer 2006.

Mr. Andersson announced that he was also retiring at the beginning of 2006.

**9. CEN TC 132 / WG 15**

The working group was now active and Mr. Boi would keep the TC members informed of the working group's progress at the June meeting.

**10. Any other business**

Mr. Mader suggested amending the last part of § 3.3.3 of the Specifications as follows:

**3.3.3 Instruments and solutions for sealing tests**

[....

The plant laboratory must have solutions available to carry out the dye spot test.

**Exception:** if a plant uses the admittance test only, the solutions for the dye spot test are not necessary.

***The Technical Committee fully agreed with this proposal and an update sheet would be prepared by the secretariat.***

Mr. Furneaux felt that QUALANOD should specify requirements for etching which was a major process.

Mr. Bettencourt explained that QUALANOD had never specified any requirements for pretreatments and appearance. However, the Technical Committee members were prepared to consider such a proposal at a future meeting.

***Mr. Furneaux agreed to prepare a concrete proposal for the June meeting.***

**11. Next meetings**

The next meetings would be held on:

<p><b>Wednesday, 28 June 2006</b> <b>and</b> <b>Thursday, 23 November 2006</b> <b>in Zurich (Hotel SOFITEL)</b></p>
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